

Date: Tuesday, 3/11/2008 10:28:32 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: N1 GEARBOX ACCESS PANEL KIT		
Job Number	: 37776-1			Part Number	: D3255042		
Estimate Number	: 12504			Drawing Number	: D3255 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 3/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: //	Type	: LARGE FAB ASSY	Due Date	: 3/28/2008		
Previous Run	: 33604			Qty:	2	Um:	Each
Written By	:						
Checked & Approved By	: <u>080311</u>						
Comment	: Est Rev.C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D32552	Panel	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Panel Batch: <u>B37887</u>	
2.0	D32553	Cap	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Cap Batch: <u>M21863</u>	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 purge weld 1-Weld as per Dwg D3255 A/R SS ROD Batch: <u>M105524</u>	
		2-Grind Welds Flush	
4.0	DO NOT USE	QC10 QC57 WELD INSPECTION 08/06/12 (x2)	
		Comment: WELD INSPECTION	
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat Grey Bandtex (Ref. 4.3.5.6) as per QSI 005 4.3 M-1 08/06/12	

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Drawing Name: N1 GEARBOX ACCESS PANEL KIT

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Part Number: D3255042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/06/12 (2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Gasket

Batch: B36779

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255

A/R 736

DOW CORNING ADHESIVE Batch: M105846

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

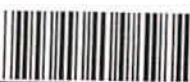
Identify and Stock

Location: PDP 37429



11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



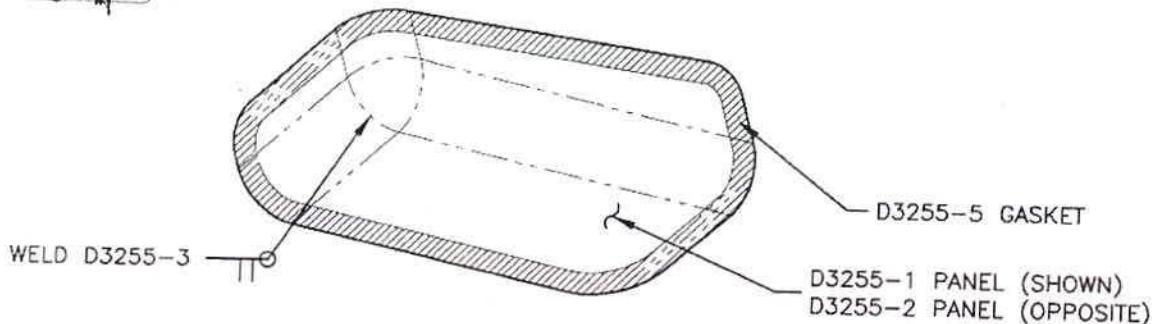
Job Completion



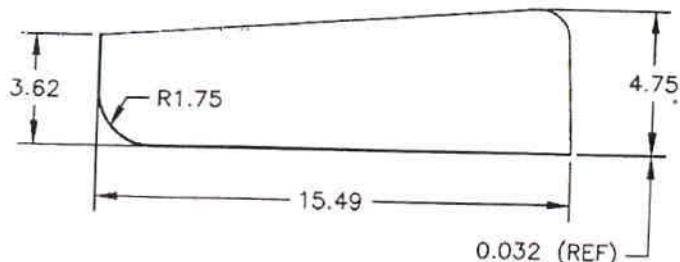
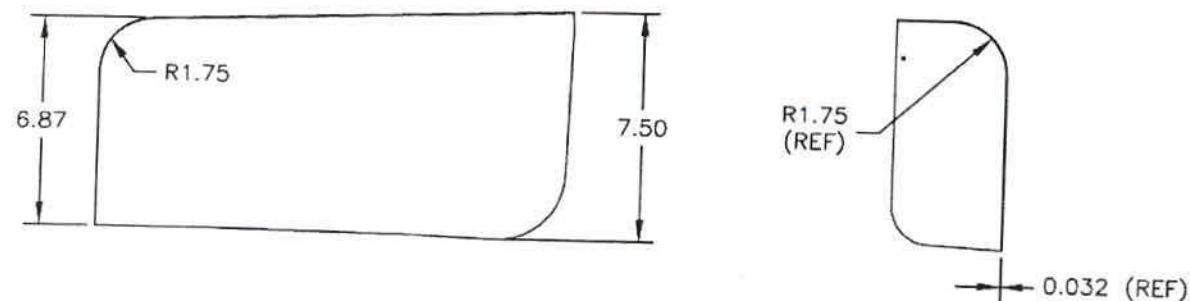
MF 08-06-27

DART

DESIGN RF	DRAWN BY TT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05.01.18 #

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

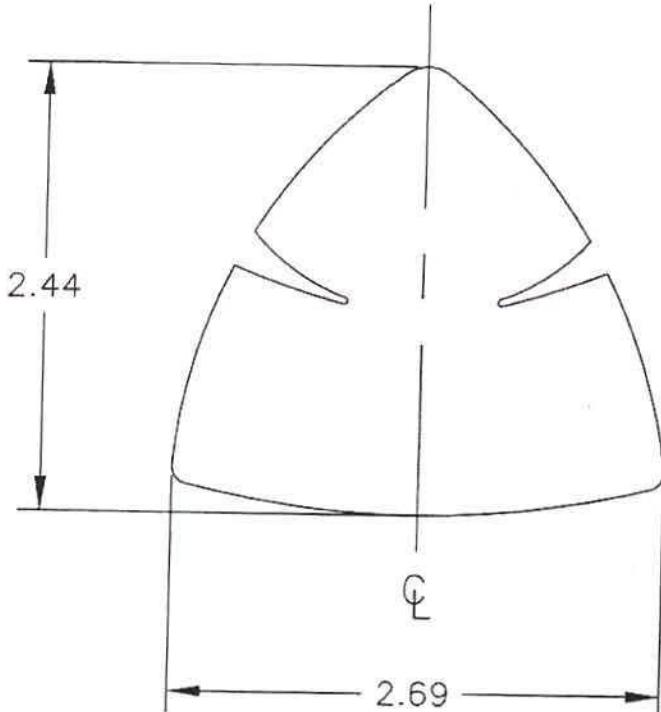
SHOP CO. A
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO.
37776

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3255
DATE		TITLE TITLE

REV. B
SHEET 2 OF 4
SCALE
1:1**RELEASED**
05.01.18 *ff*

D3255-3 CAP
FORM TO FIT D3155-1/-2

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37776*

D3255-3 NOTES:

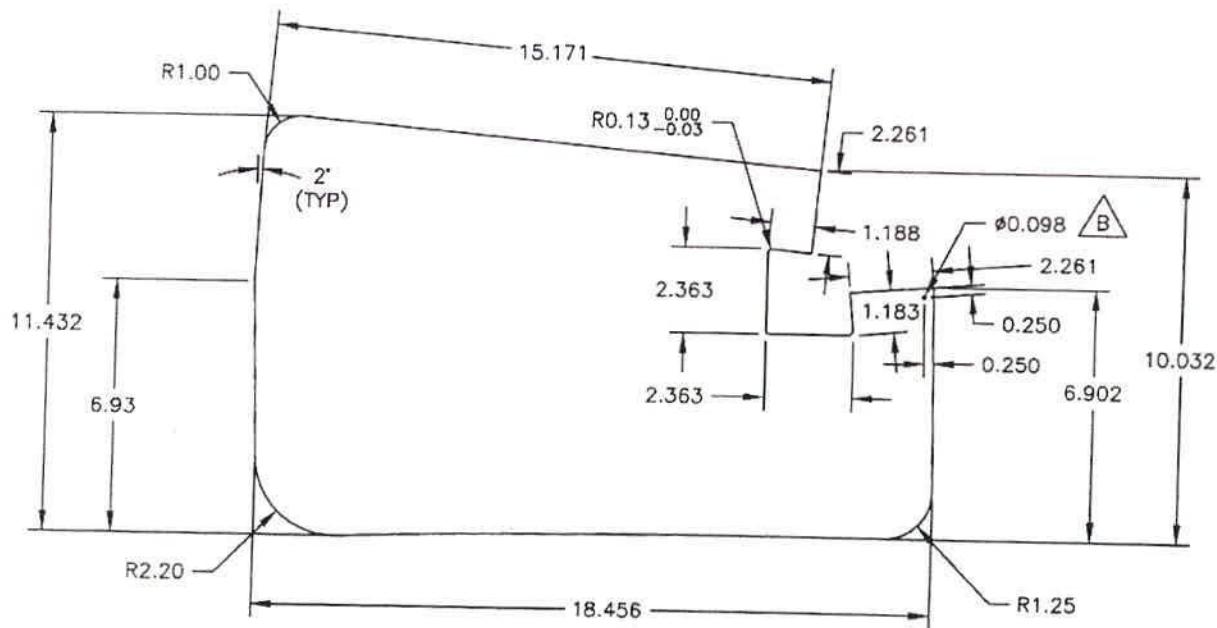
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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DART

DESIGN HF	DRAWN BY FF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18 *H*D3255-1/-2 FLAT PATTERN

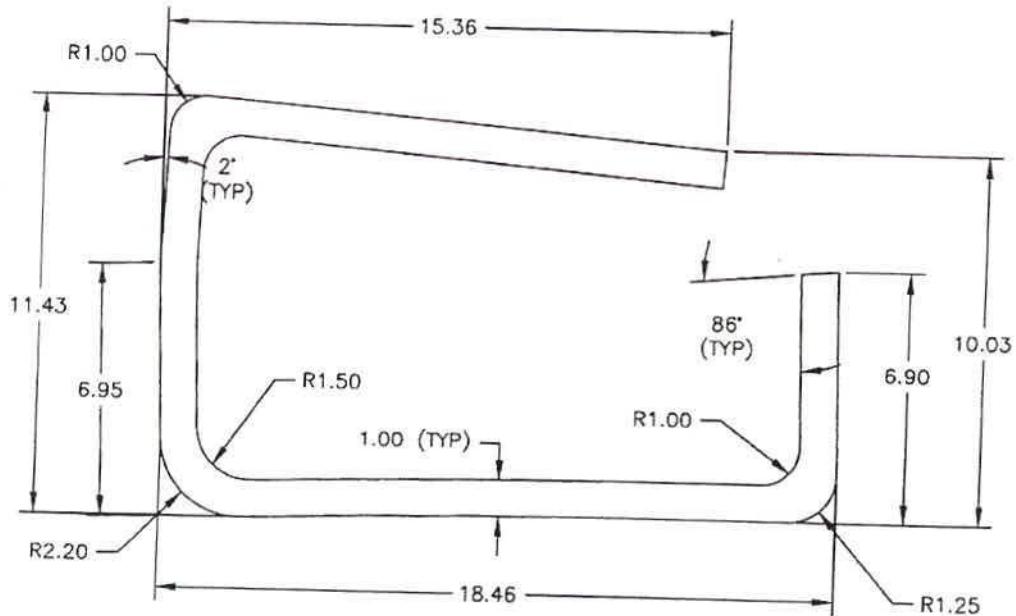
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WITHOUT NOTICE
WORK ORDER
NO. 37776

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

DESIGN <i>TT</i>	DRAWN BY <i>TT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>4P</i>	APPROVED <i>TT</i>	DRAWING NO. D3255	REV. B	SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5	

RELEASED
05-01-18 *TT***D3255-5 GASKET**

SHOP COPY
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WORK ORDER
NO. *37776*

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES